

Date: Friday, 01/08/2008 11:09:21 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: HELI ACCESS STEP EXT HIGH GEAR
<b>Job Number</b>	: 40921		
<b>Estimate Number</b>	: 12874		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D205633025
<b>This Issue</b>	: 01/08/2008	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: DSI 9300 REV B
<b>First Issue</b>	: / /	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 40669	<b>Drawing Revision</b>	: B
<b>Written By</b>	:	<b>Material</b>	:
<b>Checked &amp; Approved By</b>	: <u>JD 08.8.01</u>	<b>Due Date</b>	: 08/08/2008
<b>Comment</b>	: Est Rev:B Added D3165-1 KJ/JLM 05-09-09	<b>Qty:</b>	1 Um: Each

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy bluefile &amp; type labels per PPPD205-633-025

CHG001

S 08/08/07

2.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D2022101	Spacer
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**Comment:** Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Spacer

Batch: B37521

SQ

4.0	D2022103	Spacer
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Spacer

Batch: B35885

SQ

5.0	D2562005	Strut
-----	----------	-------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Strut

Batch: B39500

8/8/07

(1x)

SQ

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 01/08/2008 11:09:21 AM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP EXT HIGH GEAR

Job Number: 40921

Part Number: D205633025

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	D2563	Step Weldment Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Step Weldment Assembly  
Batch: B40923

7.0	D31651	Support Arm
-----	--------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Support Arm  
Batch: B34988

8.0	D2565301	Strut
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Strut  
Batch: B26639

9.0	D2565303	Strut
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Strut  
Batch: B26640

10.0	D2565305	Strut
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Strut  
Batch: B26641

11.0	D2565307	Strut
------	----------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Strut  
Batch: B26642

12.0	D2565309	Strut
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Strut  
Batch: 24448

8/8/1

(x)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 01/08/2008 11:09:22 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP EXT HIGH GEAR

Job Number: 40921

Part Number: D205633025

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	D3437045	Aft Strut Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Aft Strut Assembly

Batch: B40925

8/8/1

SP

14.0	AN45A	Bolt
------	-------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M106605

SP

15.0	AN46A	Bolt
------	-------	------



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Bolt

Batch: M107534

SP

16.0	AN47A	Bolt
------	-------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M107321

SP

17.0	AN412A	Bolt
------	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M105143

SP

18.0	AN414A	Bolt
------	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M107534

SP

19.0	AN44 7A	EYEBOLT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

EYEBOLT

Batch: M107668

\*\*\*\*\*ENSURE THIS IS AN44-7A EYEBOLT\*\*\*\*\*

8/8/1

(14)

SP

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP EXT HIGH GEAR

Job Number: 40921

Part Number: D205633025

Job Number:



Seq. #:	Machine Or Operation:	Description :
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20.0	AN514A	Bolt
------	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M104547

SP

21.0	AN960JD416	Washer
------	------------	--------



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Washer

Batch: M108161

SP

22.0	AN960JD516	Washer
------	------------	--------



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Washer

Batch: M108246

SP

23.0	MS21042L4	Nut
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Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Nut

Batch: M107478

SP

24.0	MS21042L5	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M107939

8/8/1

(X)

SP

25.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

8/8/08/07 (X)

26.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-633-025

Location:

PPP Rev: DRAFT

8/8/07 (X)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries



Date: Friday, 01/08/2008 11:09:22 AM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP EXT HIGH GEAR

Job Number: 40921

Part Number: D205633025

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

QC21

FINAL INSPECTION/W/O RELEASE



②

Comment: FINAL INSPECTION/W/O RELEASE

Done 07/08

Job Completion



mf 08-08-07

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries



DESIGN RF	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. DSI 9300	REV. B SHEET 1 OF 6
DATE 05.08.12		TITLE SIMPLEX TANK STEP	SCALE NTS
A	05.05.05	NEW ISSUE	
B	05.08.12	ADD STRUTS IF TANK REMOVED	

## DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D205-633 REV. A

REF. CANADIAN STC: SH96-57

REF. FAA STC: SR00592NY, SR00593NY, SR00594NY

THE PURPOSE OF THIS SERVICE INSTRUCTION IS TO ADD THE D205-633-021/-022/-023/-024/-025/-026 STEPS TO ADDRESS COMPATABILITY WITH THE SIMPLEX MODEL 304 FIRE ATTACK TANK. D205-633-021/-022 ARE IDENTICAL TO D205-633-011, EXCEPT AS SHOWN HERE. D205-633-023/-024 ARE IDENTICAL TO D205-633-013, EXCEPT AS SHOWN HERE. D205-633-025/-026 ARE IDENTICAL TO D205-633-015, EXCEPT AS SHOWN HERE.

NOTE THAT THE STRUTS REQUIRED TO INSTALL THE STEPS ON THE LOWER AFT HARDPOINT HAVE ALSO BEEN INCLUDED WITH THE KITS IN CASE THE TANK IS REMOVED FOR ANY REASON. THESE STRUTS SHOULD BE INSTALLED I.A.W. IIN-D205-633, EXCEPT REPLACE EYEBOLT WITH AN4 BOLT ON LOWER HARDPOINT. ALSO NOTE THAT IF THE THREADS PROTRUDE THROUGH THE BAR ON THE D3437-XXX STRUT ASSEMBLIES AFTER ADJUSTMENT THEY MAY BE TRIMMED OFF.

### WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-633-021 <b>HELI-ACCESS-STEP™</b>	14.0 lb 6.35 kg	-50.0 in -1.27 m	-700 in-lb -8.06 m kg	94.5 in 2.40 m	1323 in-lb 15.24 m kg
D205-633-022 <b>HELI-ACCESS-STEP™</b>	13.2 lb 6.00 kg	+50.0 in +1.27 m	+660 in-lb +7.62 m kg	94.5 in 2.40 m	1247 in-lb 14.40 m kg
D205-633-023 <b>HELI-ACCESS-STEP™</b>	14.3 lb 6.50 kg	-50.0 in -1.27 m	-715 in-lb -8.26 m kg	94.5 in 2.40 m	1351 in-lb 15.6 m kg
D205-633-024 <b>HELI-ACCESS-STEP™</b>	13.5 lb 6.14 kg	+50.0 in +1.27 m	+675 in-lb +7.80 m kg	94.5 in 2.40 m	1276 in-lb 14.74 m kg
D205-633-025 <b>HELI-ACCESS-STEP™</b>	14.6 lb 6.64 kg	-50.0 in -1.27 m	-730 in-lb -8.43 m kg	94.5 in 2.40 m	1380 in-lb 15.94 m kg
D205-633-026 <b>HELI-ACCESS-STEP™</b>	13.8 lb 6.27 kg	+50.0 in +1.27 m	+690 in-lb +7.96 m kg	94.5 in 2.40 m	1304 in-lb 15.05 m kg



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CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED 	
BY:	D. SHEPHERD (DE # 02)
DATE:	05.08.12
CERT. NO.:	SH96-57
ISSUE NO.:	#5

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**DART**

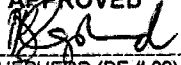
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CHECKED 	APPROVED 	DRAWING NO. DSI 9300	REV. B SHEET 2 OF 6
DATE 05.08.12		TITLE SIMPLEX TANK STEP	SCALE NTS

**PARTS LIST**

QTY -021	QTY -022	QTY -023	QTY -024	QTY -025	QTY -026	Part Number	Description
X						D205-633-021	Heli-Access-Step™ (LH), High Gear
	X					D205-633-022	Heli-Access-Step™ (RH), High Gear
		X				D205-633-023	Heli-Access-Step™ (LH), Extended High Gear (31")
			X			D205-633-024	Heli-Access-Step™ (RH), Extended High Gear (31")
				X		D205-633-025	Heli-Access-Step™ (LH), Extended High Gear (39")
					X	D205-633-026	Heli-Access-Step™ (RH), Extended High Gear (39")
4	4	4	4	4	4	D2022-101	SPACER
2	2	2	2	2	2	D2022-103	SPACER
				1	1	D2562-005	STRUT
1	1					D2562-011	STRUT
		1	1			D2562-013	STRUT
1		1		1		D2563	WELDMENT ASSEMBLY
				*1	*1	D3165-1	STRUT
1	1					D2565-101	STRUT
1	1					D2565-103	STRUT
1	1					D2565-105	STRUT
1	1					D2565-107	STRUT
1	1					D2565-109	STRUT
*1	*1					D2565-111	STRUT
		1	1			D2565-201	STRUT
		1	1			D2565-203	STRUT
		1	1			D2565-205	STRUT
		1	1			D2565-207	STRUT
		1	1			D2565-209	STRUT
		*1	*1			D2565-211	STRUT
				1	1	D2565-301	STRUT
				1	1	D2565-303	STRUT
				1	1	D2565-305	STRUT
				1	1	D2565-307	STRUT
				1	1	D2565-309	STRUT
1	1					D3437-041	AFT STRUT ASSEMBLY
		1	1			D3437-043	AFT STRUT ASSEMBLY
				1	1	D3437-045	AFT STRUT ASSEMBLY
	1		1		1	D3438-042	WELDMENT ASSEMBLY
1	1	1	1	1	1	AN4-5A	BOLT
4	4	3	3	3	3	AN4-6A	BOLT
1	1	1	1	1	1	AN4-7A	BOLT
1	1					AN4-11A	BOLT
		1	1	1	1	AN4-12A	BOLT
1	1	1	1	1	1	AN4-14A	BOLT
1	1	1	1	1	1	AN44-7A	EYEBOLT
1	1	1	1	1	1	AN5-14A	BOLT
16	16	14	14	14	14	AN960JD416	WASHER
3	3	3	3	3	3	AN960JD516	WASHER
8	8	7	7	7	7	MS21042L4	NUT (or MS21042-4)
2	2	2	2	2	2	MS21042L5	NUT (or MS21042-5)

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CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED  
BY:   
D. SHEPHERD (DE # 02)  
DATE: 05.08.12  
CERT. NO.: SH96-57  
ISSUE NO.: #5

\* ONLY INSTALLED IF TANK IS REMOVED

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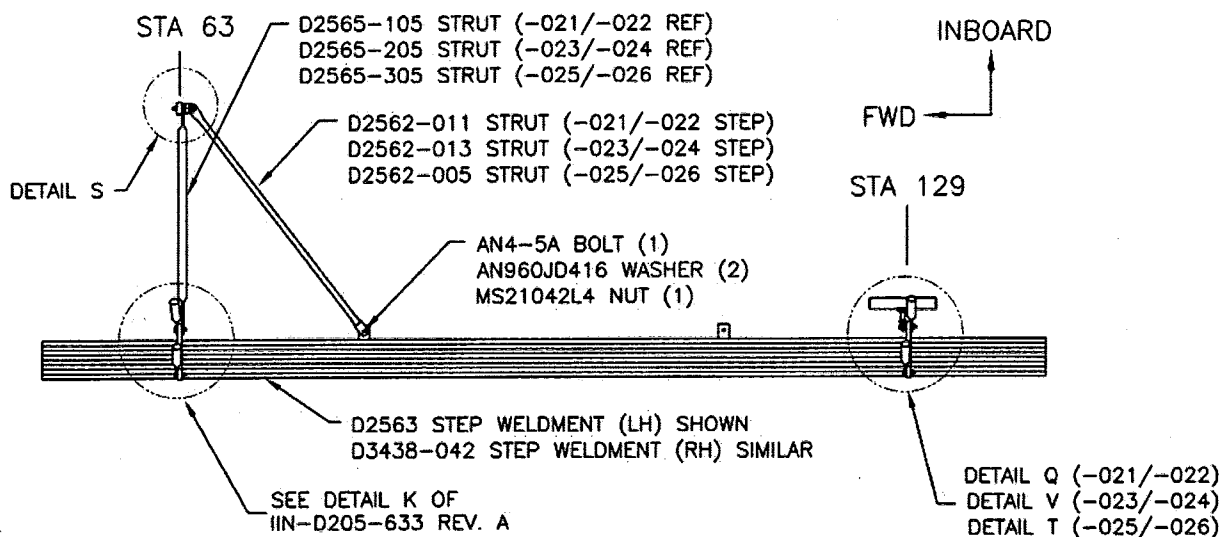
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. DSI 9300	REV. B 3 OF 6
DATE 05.08.12	TITLE SIMPLEX TANK STEP KIT		SCALE NTS

### INSTALLATION OF D205-633-021/-022/-023/-024/-025/-026

INSTALL D205-633-021/-022 AS PER THE D205-633-011 STEP OF INSTALLATION INSTRUCTIONS IIN-D205-633 REV.A, EXCEPT REPLACE D2565-111 STRUT WITH THE D3437-041 AFT STRUT ASS'Y, REMOVE D2562-001 STRUT, INSTALL D2562-011 STRUT AS SHOWN.

INSTALL D205-633-023/-024 AS PER THE D205-633-013 STEP OF INSTALLATION INSTRUCTIONS IIN-D205-633 REV.A, EXCEPT REPLACE D2565-211 STRUT WITH THE D3437-043 AFT STRUT ASS'Y, REMOVE D2562-003 STRUT, INSTALL D2562-013 STRUT AS SHOWN.

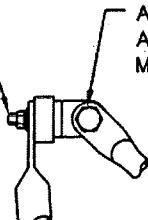
INSTALL D205-633-025/-026 AS PER THE D205-633-015 STEP OF INSTALLATION INSTRUCTIONS IIN-D205-633 REV.A, EXCEPT REPLACE D3165-1 SUPPORT ARM WITH THE D3437-045 AFT STRUT ASS'Y AS SHOWN.



**D205-633-021/-023/-025 SHOWN.**  
**D205-633-022/-024/-026 SIMILAR**  
(VIEW LOOKING DOWN)

AN44-7A EYEBOLT (1)  
AN960JD516 WASHER (1)  
MS21042L5 NUT (1)

**DETAIL S**  
NOT TO SCALE



AN4-6A BOLT (1)  
AN960JD416 WASHER (2)  
MS21042L4 NUT (1)

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DAO # 01-O-01

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BY:   
D. SHEPHERD (DE # 02)

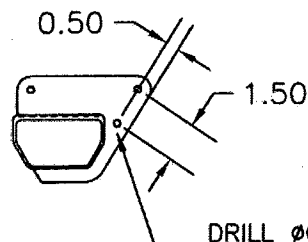
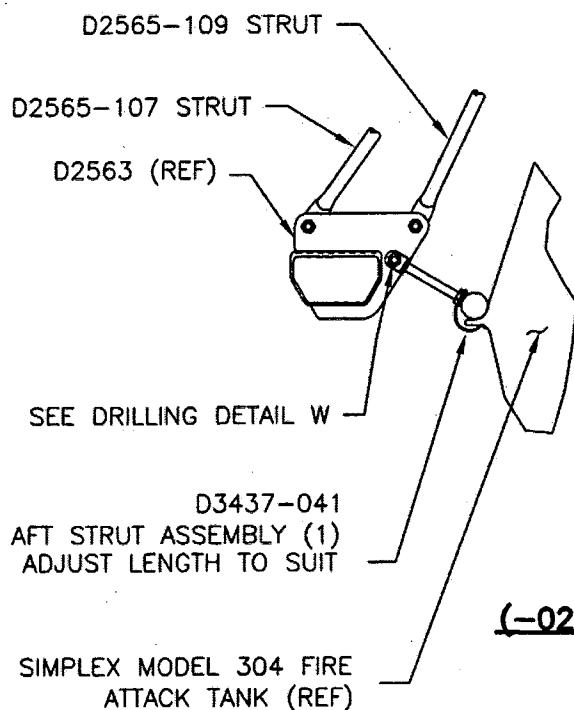
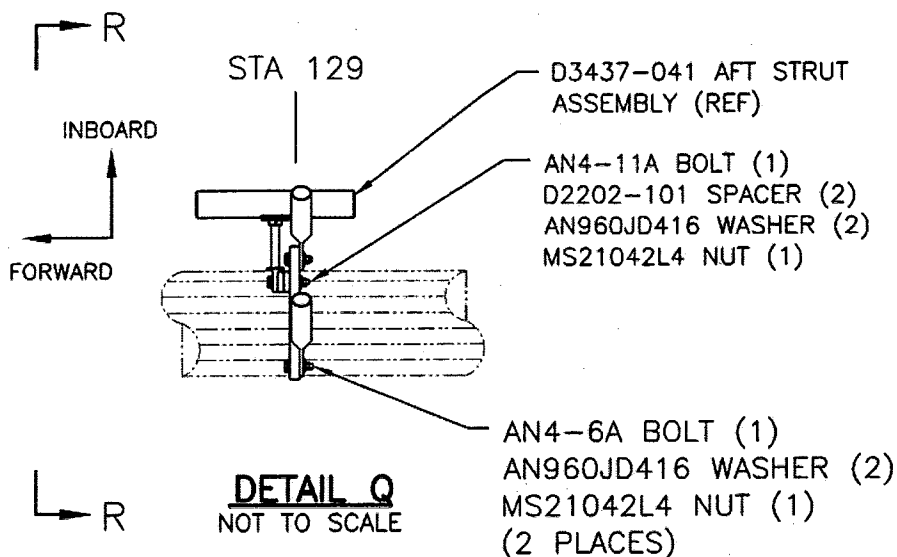
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DATE 05.08.12	TITLE SIMPLEX TANK STEP		SCALE NTS



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**(-021/-022 STEP)**

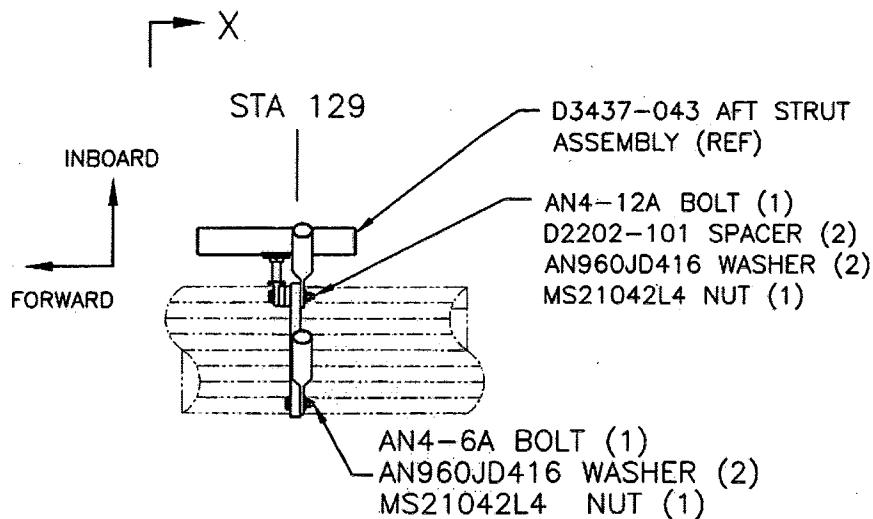
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BY:	D. SHEPHERD (DE #02)
DATE:	05.08.12
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ISSUE NO.:	#5

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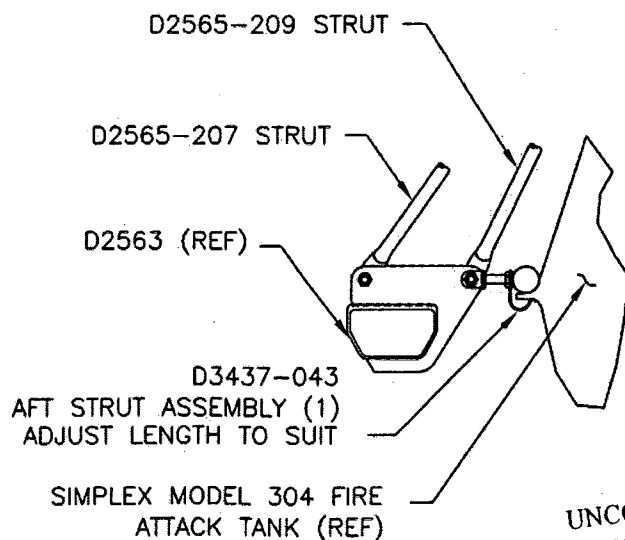
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DATE 05.08.12	TITLE SIMPLEX TANK STEP		SCALE NTS



**DETAIL V**  
NOT TO SCALE



**(-023/-024 STEP)**

**VIEW X-X**  
NOT TO SCALE

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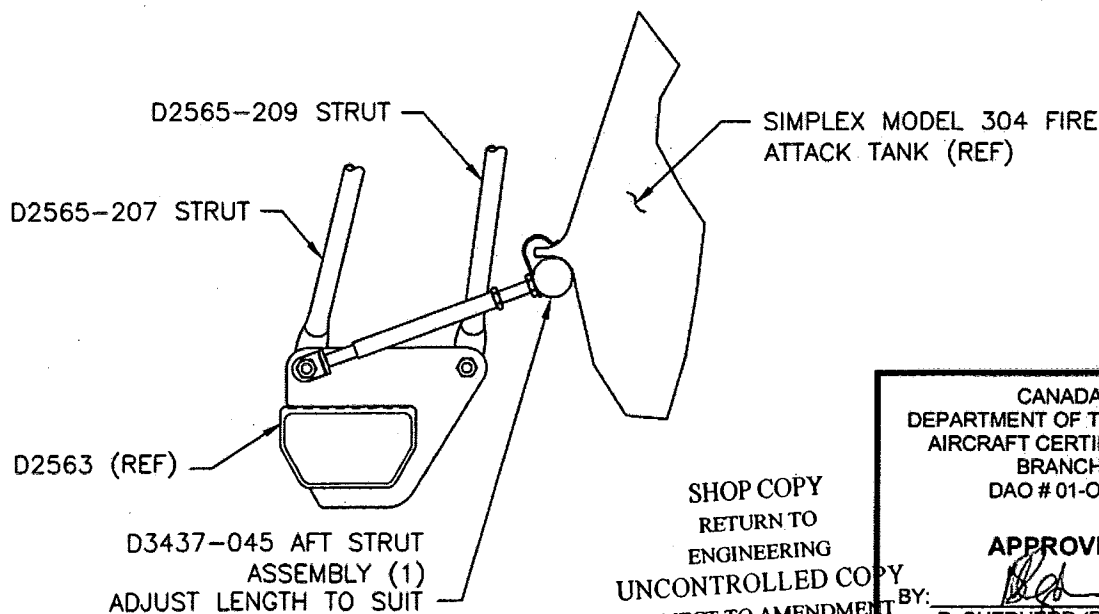
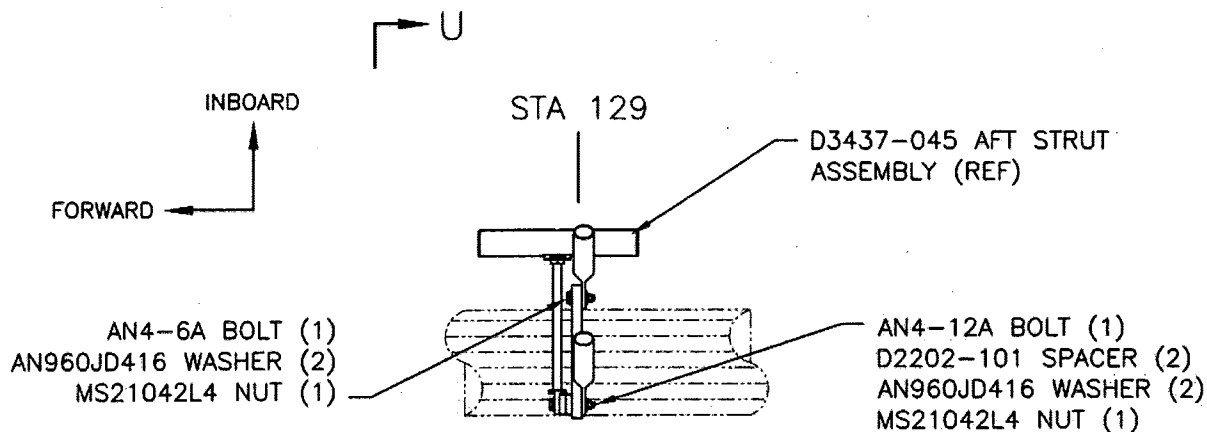
CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
<b>APPROVED</b> <i>[Signature]</i>	
BY:	D. SHEPHERD (DE # 02)
DATE:	05.08.12
CERT. NO.:	SH96-57
ISSUE NO.:	#5

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DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

**APPROVED**

BY: *[Signature]*  
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